

ASAP GenV2

Date: Friday, 19/01/2007 8:50:49 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DND001 Department of National		Drawing Name	: STIFFENER	
Job Number	: 30331				
Estimate Number	: 12659				
P.O. Number	: N/A		Part Number	: G106102	
This Issue	: 19/01/2007	S.O. No. : N/A	Drawing Number	: G10610 REV A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: N/A		Material	: N/A	
Written By	:		Due Date	: 26/01/2007 Qty: 10 Um: Each	
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 07-01-18 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1510 sf(s)/Unit Total : 1.5100 sf(s) 2024-T3 .040 sheet Batch: M102448 (20)	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg G10610 Dwg Rev: 106102 Prog Rev: A	
			SB 07/01/22 (10)
		2-Deburr if necessary	
		****USE SAME CUTTING FILE FOR -1 & -2****	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	

Date: Friday, 19/01/2007 8:50:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DND001 Department of National

Drawing Name: STIFFENER

Job Number: 30331

Part Number: G106102

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Formas per Dwg G10610

SB 07/01/2007

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/2007

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YH 07/01/2007

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/01/2007 (10)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

Box 100 07/01/2007

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/2007 (10)

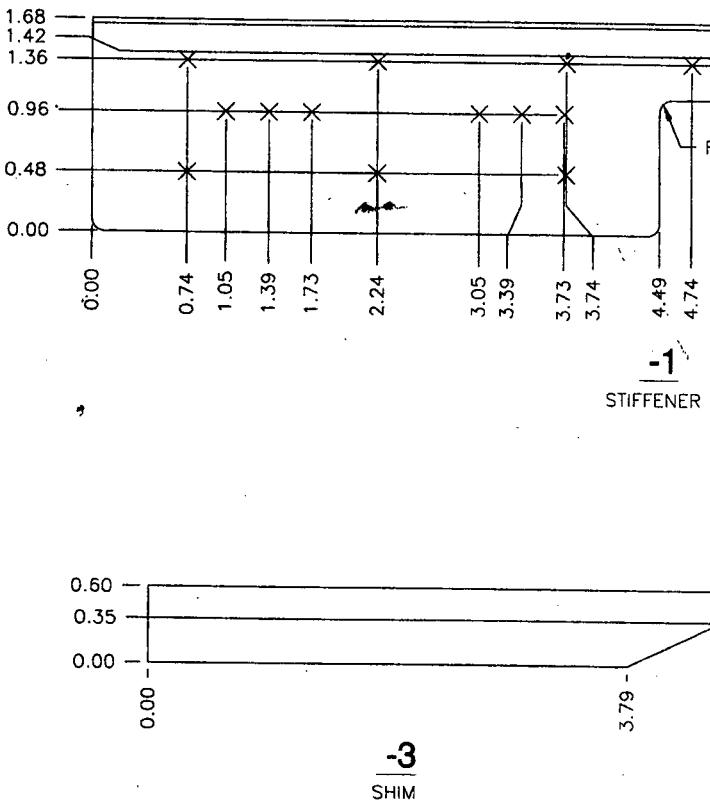
Job Completion



07/01/2007

W/0 3033

REV	DESCRIPTION	DATE	APROV.
A	9.75 WAS 8.98, 9.00 WAS 8.25, ADDED MATERIAL CALLOUT FOR -3	4/8/01	CLB



-1
STIFFENER
(OPPOSITE BEND)

-2
(OPPOSITE BEND)



NOTES:
UNLESS OTHERWISE NOTED,

1. MAT'L:
Ⓐ -1 ALUM, 0.04 THICK, 2024-T4 AU4G1.
-2 ALUM, 0.04 THICK, 2024-T4 AU4G1.
-3 ALUM, 0.05 THICK, 2024-T4 AU4G1.
2. INSIDE BEND RADIUS: 3T, 90°±5°.
3. FINISH: ETCH, ALODINE PER MIL C5541-1A,
PAINT WITH ACRYLIC URETHANE.
4. ALL HOLE LOCATIONS ARE RECOMMENDED REFERENCE ONLY.
FINAL LOCATIONS TO BE DETERMINED AT INSTALLATION.
MATCH DRILL PARTS AT ASSEMBLY.

BREAK ALL EDGES ✓ UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES DIMENSIONAL TOLERANCES		DRAWN DT	DATE 4/3/98
		CHECK	DATE
		DESIGN	DATE
3 DECIMALS ± .020 2 DECIMALS ± .020 1 DECIMAL ± .050 ANGULAR ± 1°		APPROVAL DCF	DATE 4/3/98
TITLE GENEVA AVIATION 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100			
REAR SHOULDER HARNESS INSTALLATION MODIFICATION			
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.		DWG NO. G10610	REV. A
		PRO NO. GA159	SIZE B
		SCALE 1/1	SH. 1 OF 2

DART AEROSPACE LTD	Work Order:	30331
Description:	Part Number:	G10G102
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	SAD	Audited by:	<u>A</u>	Prototype Approval:	
Date:	07/01/22	Date:	07/01/23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

VPK METAL
DART AEROSPACE
ALUMINUM SHEET 2024-T3
.040 Nom X 48.0000" X 144.0000"
PART NO.

PO/Rel PO000002219

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Certificate of Mill Test Results

BL-PEC-432265-001

19Oct06

Pg 1/2

Signed by: _____

Attn: _____

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Marty Vrablec

Marty Vrablec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From:

Page 1

617430	0	B.L. No.	Invoice No.	Alcoa No.	Item
2006-05-30	1503480	00000	1881283-1		
P.O. No./Govt Contract No.		Customer Mfg Order			
CJ3347		C&B		DS-81283-1	

Ship To: COPPER BRASS SALES
1715 WOODLAND DRIVE
SALINE, MI 48176

Item Description
0.0400 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126137 (N) A/T 2024-
T3 FLAT SHEET MILLE FINISH ((P/N 061825-6)). PER AMS-QQ-A-
250/4 REV A & (EX. OIL&MARK)
AMS4037 REV N & (EX. MARK) ASTMB209 REV 04
(MARKED) INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR D126137 REV 22 CUST REQ 06-05-
28 *** W/E 06-06-03 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	383823		718351	3902	142	PC	

Notes for CQR: D126137.22

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126137.22 -Specification Limits -----

Temp	Dir	UTS		TYS		EL4D	
		Max	Min	KSI	KSI	PCT	PCT
T3	Long Transv.	Max	Min	63.0	42.0	15	

Chemical Composition	Other Other											
	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
	Min			3.8	.30	1.2						REMAIN

Lot: 718351 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	Test	No.	UTS		TYS		EL4D	
			Max	Min	KSI	KSI	PCT	PCT	
T3	Long Transv.	6	Max	67.6	45.5	20.2			
			Min	66.9	44.6	18.5			

G10610-2 B 30331